Dart Aerospace Ltd. Wednesday, 5/23/2007 3:43:17 PM Date Kim Johnston **Process Sheet** : STEM **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 32503A : 10399 **Estimate Number** : D29683 Part Number : NA P.O. Number S.O. No. : 1/1/ D2968 **Drawing Number** : 5/23/2007 This Issue : N/A Project Number Prsht Rev. : MACHINED PARTS **Drawing Revision** ; B1 Type First Issue JIV. : 30275A Material Previous Run : 6/30/2007 Due Date Written By Checked & Approved By Reformat; Incorporated D2968-1/-5 KJ/RF Comment : Est:C 03.04.11 **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 4130 steel rod .750" M4130NR0750 1.0 0.3762 f(s) Comment: Qty.: 0.3762 f(s)/Unit Total: Material: AISI 4130 Ø 3/4 " Bar Batch: MIOYYSA (M4130N-R0.750) Identify AS D2968-3 ralzolro HARDINGE CNC LATHE SMALL 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Folio FA048 and Dwg D2968 2-Deburr, no sharp edges INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE HAAS CNC VERTICAL MACHINING #1 4.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA048 and Dwg D2968

INSPECT PARTS AS THEY COME OFF MACHINE

5.0

2- Deburn

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC2

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W/O:		•	WORK ORDER	CHANGES				
DATE	STEP	STEP PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	):	PAR #:	Fault Category:	NCR: Yes	No DQ	A: <u></u>	Date:	sykuas
				QA:	N/C Close	d:	Date: _	
NCR: WORK ORDER NON-CONFORMANCE (NCR)								

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Chief EngAction Description Chief EngSign & Date		Section C	Approval Chief Eng	Approval QC Inspector	

NOTE: Date & initial all entries

Wednesday, 5/23/2007 3:43:17 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: STEM Customer: CU-DAR001 Dart Helicopters Services Job Number: 32503A Part Number: D29683 Job Number: Description: Seq. #: Machine Or Operation: SECOND CHECK 6.0 QC8 1.06.22 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0

Job Completion

Comment: FINAL INSPECTION/W/O RELEASE



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W/O:			WORK ORDER CHANGES							
DATE STEP			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•		PAR #:	Fault Category:		_ NCR: Yes	No <b>DQ</b>	A:	Date:	···

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector			
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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	32503A
Description: Stem	Part Number:	D2968-3
Inspection Dwg: D2968 Rev: B1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.200	+/-0.010	4.200				
3.180	+/-0.010	3.177	1			
2.430	+/-0.010	2.436	1			
0.470	+/-0.010	.411				
0.250	+/-0.010	٠٦٢٦				
0.550	+/-0.010	.555	<u></u>			
Ø0.750	+/-0.010	.746				
Ø0.625	+/-0.010	.624	·-			
Ø0.363	+/-0.010					
0.250	+0.010/-0.000	,365 _,252"				
0.625	+/-0.010	,625" ,155"	<u></u>			
0.150	+/-0.010	,155*				
1/4-28 UNF	N/À	14-28	~			
B 0.125"	**************************************	B 125"			<u> </u>	
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				. •		

Measured by:	N8/J.F.	Audited by:	az	Prototype Approval:	N/A
Date:	orlosias	Date:	01.06.22	Date:	N/A

Rev	Date	Change		Revised₁by	Approved
Α	04.02.25	New Issue	P/O D2968-043	KJ/RF KJ/RF	<del> </del>

